Work Orde		39				Page 1								
Revision ID: Item Name: Start Date:		Start Qty: 2.00		*2*	Accept	*	N900		100	ገ*	Setup	Start Stop	*N:	S1* S2*
Required Date:	4/11/13	Req'd Qty: 2.00	•	*2*			Customer:					-		*
Reference:		·							-		Run	Start	411	- 4 +
Approvals:	Process Plan	ı: <i>[</i>	Date: x	B-04/6	Tooling:		D	ate:			Kun		^N!	R1^
	QC:		Date:_		SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center II		Operation Description			Set Up/ Run Ho		Tool ID	Tool#	Plan Code	Accep Qty	t Re Qt	•	Reject Number	Insp. Stamp
Draw Nbr	Revis	sion Nbr												
D3007	Rev	A1												
*100		Small Fab			0.00					$2 \propto$		-147.		1331
Small Fab Small Fab		Memo Assemble	as per Dwg D	3007	0.00									
110		QC5- Inspect part com	pleteness to st	tep on W/O	0.00					_				
110		Memo		·	0.00	27				C				
Quality Control						134	93							
120		Identify as per dwg &			0.00						//	//2	1 60	
120 Packaging Packaging		Memo	5)	259	0.00					/	<u></u>	<u> </u>	7/28	

NCR: Y	res / N	ا ٥			WORK ORDER NON-C	CONF	JRN	MANCE / UPDA		QA Closed:	Date	::
Work Orde	or.				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	· · · · · · · · · · · · · · · · · · ·
Part N					Rework Scrap]	ſ	Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality Other
NCR N	No	!			Use-as-is Work Order Update] ''		noforming C	Finishing Composite	Rec/Stor	Supplier	Other
Root				1	ption of work order update	Initi		Action		Sign &		
Cause	Date	e Step	Qty		or Non-conformance	Chief	Eng	Descript	tion	Date	Verification	QC Inspector
Doc/Data									ļ			
Equip/Tooling			1									
Operator		ı				Ì						,
Material												
Setup												
Other		,										
Process		1				1						
Supplier		!										
Training												
Unapproved			1									
					F	AULT C	ATE	GORY				
Landir	ng Gear	r			General					1	_	
	Bendir	ng !			Bend	Gra	ain			Ovalized		Pressure/Forced
	Centre	Not Conce	entric to	o/s	BOM/Route	Hai	rdwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks	ſ			Broken/Damaged	Ins	pecti	ion Incomplete		Part Incorre	ct	Weld
	Crushe	d/Crimped	I.		Burrs	Ins	truct	ions Incomplete/Unc	lear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs	ı			Contamination	Má	ainte	enance		Part Moved		
	Heat T	reat			Countersink	Mi:	slabe	eled		Positioned V	Vrong	<u> </u>
	Inspec	tion Strip ir	n Tube		Cut Too Short	Mi:	sread	t		Power Loss/	Surge	Other
	Ripple	s in Bend			Drill Holes	Off	set					
	Torque	Waves in	Extrusio	n	Drawing	Ou	t of (Calibration				
	Turnin	g Sequence	9		Finish	Out of Sequence						
	Wave/	Twist in Tu	be		Folio	Outside Dimensions						

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord		0639				*996	339*							Page 2
Item ID: Revision ID: Item Name:	D3007-041 Strut					Accept	*N900	<u>040</u>	100)* s	Setup	Start Stop	ı Vi .	S1* S2*
Start Date: Required Date	4/11/13	Start Qty: Req'd Qty			*2* *2*		Cust Item 1 Customer:						ı v.	. 12
Approvals:	Process Pla	an:	1	Date:		Tooling: SPC (Y/N):		ate:	-	F	Run	Start Stop	1/1	R1* R2*
Sequence ID/ Work Center I	D	Operation Description QC21- Final In		- Work Order	Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
130		N	lemo			0.00					-	17	10/6	70

Memo

Quality Control

MF 13-4-29

												DQA:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-C	O	VFORI	MANCE / UPI	DATE		QA Closed:	Date	:
Work Orde	or.					DISPOSITION				AGAIN	IST DEI	PARTMENT	/PROCESS	
Part I	- . No.					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstu Small F Finish Compos	ab ing		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	otion of work order update	ı	nitial	Act	tion		Sign &		
Cause		Date	Step	Qty	c	or Non-conformance	Ch	ief Eng	Desci	ription		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
							AUL	T CATE	GORY					
Landi		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in	Crimped it n Strip in Bend	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/I nance iled	Unclear	}	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	1 i	Torque W	laves in F	ytrusin	n I	l Drawing	1	IOut of (`alibration					

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

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Picklist Print

April-11-13 2:28:55 PM

Work Order ID:

99639

Parent Item:

D3007-041

Parent Item Name:

Strut

Start Date: 4/11/13

Required Date: 4/11/13

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	. Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3007-1		Manufactured	No			100	Each	2.0000	1	2	5/1		/ /
Strut		1							c. z. v	es at tur en ce	45	[3_/_	04 fo
		i		Location		Loc Qty	<u>L</u>	oc Code					
		:		ST259		2				<u></u>			
		1		6141	2	2			c	<u> </u>			/
D2012-107	•	Manufactured	No			100	Each	16.0000	1	2			/ /
Clevis												3/07	135
				Location		Loc Qty	<u>L</u>	oc Code				/ /	
		•		WA004		16				/		•	•
		•		8586	52	4							
		•		9212	3	12				2_		,	/ /
02022-101		Manufactured	No			100	Each	176.0000	2	4		1 1	1/
Spacer												3/09	100
				Location		Loc Qty	<u>L</u>	oc Code				/ /	
				ST004		176				,			
				9014		33				<u> </u>			
		1		9286		33				,—			
		i		9723 9845		50 60				<u>/</u>			
4 N/4 10 A			Nia	9845	10		F1	04.0000			///	· /	
AN4-10A Bolt		Purchased	No			100	Each	94.0000	1	2	1/3	104 1	25-
SOIL		111									77		 ,
		*) 		Location		Loc Oty	<u>1.</u>	oc Code					
				ST356	.05	94				1			÷
		I .		1224 1228		40 4							
		i		1226		50				·	0.		1
- AN960JD416	NAS1149D0463J	Purchased	No	.233		100	Each	0.0000	1	2			. / .
Washer		i ui ciiaseu						******	<u>-</u>		[]	104	25
	/ in	1 .					1174	19'd /				7	
	7	1				$\sqrt{\Gamma}$	1101	100/	2(V)				

NCR: Ye	s / No	ľ	,		WORK ORDER NON-C	CONI	FORN	MANCE / UPI	DATE	QA Closed:	Date:	
Work Order	:	1			DISPOSITION				AGAINST DE		PROCESS	
		i			Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part No)				Scrap	11		Machining	Small Fab		d. Eng. Coor.	Quality
NCR No)	!			Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root	T		Π	Descri	ption of work order update	In	itial	Act	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chie	f Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling		1										
Operator		i.										
Material												
Setup											•	
Other		!										
Process		1										
Supplier		,				1						
Training		'	1 1			į						
Unapproved												
						AULT	CATE	GORY				
Landing	_	r		_	General				_	٦		٦- /- /
<u> </u>	Bending	!		<u> </u>	Bend	\vdash	Grain		 	Ovalized	<u> </u>	Pressure/Forced
	Centre No	ot Concei	ntric to C)/S	BOM/Route		lardwa		 	Over/Under		Temperature/Cure
_	Cracks	!			Broken/Damaged	\vdash		on Incomplete		Part Incorre	-	Weld
_	Crushed/	Crimped	-	<u> </u>	Burrs	-		ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
L	Cuffs	r f		·	Contamination			enance	<u> </u>	Part Moved		
L	Heat Trea			L	Countersink	-	∕islabe			Positioned V		70
	Inspection		Tube	<u> </u>	Cut Too Short	\vdash	∕lisreac	t		Power Loss/	Surge	Other
<u> </u>	Ripples in			<u> </u>	Drill Holes	\vdash	Offset		-		,	
	Torque W	1			Drawing	-		Calibration				
	Turning S	equence			Finish	Щ	Out of S	Sequence				

Outside Dimensions

DQA:

Date:

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Wave/Twist in Tube

Folio

April-11-13 2:28:55 PM

Work Order ID:	99639						
Parent Item:	D3007-041				Start Da	ite: 4/11/13	Required Date: 4/11/13
Parent Item Name:	Strut	ı			Start Q	ty: 2.00	Regulyed Qty: 2.00
MS21042L4			No	100 Each	2,021.0000	1	2 //
Nut		Turchased					(1)13/04/25
		İ	Location	Loc Qty	Loc Code		
		I	FP001	318	200 0000		
		1	122452	306			-/
		l	8182	12			
		i	FP-001	12		-	_
			8182	12			_
			GA S182	2			_
			121444	2			_
		i				-	
			ST314 116548	76 4			
		1	119017	20			_
		1	123248	36			
		1	123355	16			
			ST518	1613			
		1	124231	1613		2	_ / / / /
D2705		Manufactured	No	100 Each	5.0000	1	2 10/
Support Bracket		Manufactured					- 2 / DI JOY 104 195
Support Bruener			Location	Loc Qty	Loc Code		
					.,	_	
	į	I	ST016	5)	
	į		36329 62357	3 2		$-\infty$	- 1
		_ 1			n 196.0000	1	-, // / / /
SL69-BS		Purchased	No ·	100 Each	1 190.0000	1	2 / 3 /04/25
Ball Stud		. 1			•		
			Location	Loc Oty	Loc Code		
		· · · · · · · · · · · · · · · · · · ·	GA	142			_/ .
		1	124455	142		_ <	
			ST397	54			
		:	118145	54			
		•					

			1								DQA:	Date	:		
NCR: Y	Yes ,	/ No				WORK ORDER NON-C	100	NFOR!	MANCE / UPDATE						
											QA Closed:	Date	· · · · · · · · · · · · · · · · · · ·		
Work Orde	~ r ·		1			DISPOSITION			AGA	INST DE	PARTMEN T ,	/PROCESS			
Work Orde	=' -					Rework]		Skid-tube Cross	tube		Water Jet	Engineering		
Part N	No.		1			Scrap	1	I .	Machining Smal		Pro	d. Eng. Coor.	Quality		
	_		- -			Use-as-is	1	Therm	oforming Finis	hing	Rec/Stor	e/Packaging	Other		
NCR N	No					Work Order Update]		Large Fab Comp	ab Composite Supplier					
								<u></u>			_				
Root			-		'	ption of work order update	1	Initial	Action		Sign &		061		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector		
Doc/Data	Ш			,	3										
Equip/Tooling	P		i												
Operator			i												
Material			ļ	,											
Setup															
Other	Ш														
Process	Ш		<u> </u>												
Supplier	Ш		·												
Training]. j		-			:							
Unapproved												<u> </u>			
			ļ- -				AUI	LT CATE	GORY						
Landi			1			General		7		_	1	Г	¬ .		
	_	ending				Bend	<u></u>	Grain		<u> </u>	Ovalized		Pressure/Forced		
		entre No	ot Goncei	ntric to	o/s	BOM/Route	_	Hardwa		ļ	Over/Under	-	Temperature/Cure		
	_	racks	*.			Broken/Damaged	_	- ·	on Incomplete		Part Incorre	j	Weld		
		rushed/0	Crimped.			Burrs	\vdash	- 4	ions Incomplete/Unclear	 	Part Lost/M	issing	Wrong Stock Pulled		
	Щc	uffs	ı			Contamination		Mainte			Part Moved				
	Щн	eat Trea	it		L	Countersink	Mislabeled					Vrong r	 1		
	∐ ir	rspection	n Strip in	Tube		Cut Too Short	Misread					'Surge	Other		
	R	ipples in	Bend		Drill Holes Offset										

Out of Calibration Out of Sequence

Outside Dimensions

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

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April-11-13 2:28:55 PM

Work Order ID: Parent Item: Parent Item Name:	99639 D3007-041 Strut	:						Date: 4/11/13 Qty: 2.00	Required Date: 4/11/13 Required Qty: 2.00
D3015-3 Locknut		Manufactured	No		100	Each	348.0000	1	2 /3/04/25
	•	i		Location	Loc Qty		Loc Code		
				FG 96151 ST023 95758 97511	2 2 346 46 300				
AN960JD516 Washer	NAS1149D0563J	Purchased	No	Location ST504 1069059	100 <u>Loc Qtv</u> 2	Each	2.0000 <u>Loc Code</u>	1	2 5/3/04/25

NCR: Ye	es / No	!			WORK ORDER NON-C	CONFO	RMANCE / UI	PDATE	QA Closed:	Date:	
	311.2.2.2.2.2.2.2.2.2.2.2.2.2.2.2.2.2.2.		* • 3.								· V · 40.00
Work Order	r·	1			DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
		!			Rework	1 	Skid-tube	Crosstube]	Water Jet	Engineering
Part No	0.	1			Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
		i			Use-as-is	The	rmoforming	Finishing	Rec/Sto	re/Packaging	Other
NCR No	0	1	 		Work Order Update]	Large Fab	Composite]	Supplier	
Root				Descri	ption of work order update	Initial	Initial Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Er	g Des	scription ·	Date	Verification	QC Inspector
Doc/Data		1									
Equip/Tooling		į.									
Operator		1									
Material	_										
Setup	_	'									
Other	_	1		. •							
Process	_					-	-				
Supplier	\dashv	1.1									
Training		1									
Unapproved			ł	<u> </u>	F	AULT CA	TEGORY		<u> </u>		
Landin	g Gear	ľ			General						
	Bending	ļ		Г	Bend	Grain	1		Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route	Hard	ware	ļ	Over/Under	tolerance	Temperature/Cure
F	Cracks	i			Broken/Damaged	Inspe	ction Incomplete		Part Incorre	ect	Weld
Ī	⊣ ' ⊢ ⊣				Burrs	Instru	ictions Incomplete	e/Unclear	Part Lost/M	lissing	Wrong Stock Pulled
Ī					Contamination	Mair	itenance		Part Moved		
Heat Treat Countersink					Countersink	Misla	beled		Positioned \	Wrong	-
	Inspectio	n Strip in	Tube		Cut Too Short	Misre	ead		Power Loss,	/Surge	Other
Ripples in Bend Drill Holes					Drill Holes	Offse	t				
	Torque W	aves in E	Extrusio	n [Drawing	Out of Calibration					

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

